

9

Date: Monday, 1/7/2008 4:28:59 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 36652D		
Estimate Number	: 12357		
P.O. Number	:	Part Number	: D41269404
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: D412-694
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C1
Previous Run	: 27446	Material	:
Written By	:	Due Date	: 2/28/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>08.01.8</u>		
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF		
	: Est Rev: B 06.04.18 New dwg rev. ecn781 EC		
	: Est Rev: C 06.07.10 Revised per B24659 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-04. CHG005

2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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Comment: COMPOSITE ASSEMBLY

D412-694-04 Drill Process

1- Drill pilot holes Ø(#30) using Dwg Tool D3140-303A for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T11/-T12 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference. ✓

2- Drill Pilot holes Ø(#30) using drill Jig D3120-4T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3. ✓

3- Drill Pilot holes Ø(#30) using drill Jig DT8703-10 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM). ✓

4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-11. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF). ✓

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-12. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF). ✓

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom. ✓

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert top and bottom. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA). ✓

08/02/04

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Description :

3.0

QC5

INSPECT WORK TO CURRENT STEP



*Insert ①*



Comment: INSPECT WORK TO CURRENT STEP

4.0

8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

M19443

M105573

Mars 2008

*ml 08/02/07*

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

*ml 08/02/07*

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Insert ①*



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

7.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch:

106 807

A/R 12375S

Reducer

Batch:

106 803

*08-02-07*

8.0

QC5

INSPECT WORK TO CURRENT STEP



*Insert ①*



Comment: INSPECT WORK TO CURRENT STEP

9.0

D31101

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Escutcheon

Batch

B31757

*ml 08/02/07*

W/O:		WORK ORDER CHANGES					
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Description :

10.0

D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B36724

*ml*

11.0

D311041

Plate Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Plate Assembly

Batch

M10536-17

*ml*

12.0

D31121

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch

B35122

*ml*

13.0

D31131

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring

Batch

B17437

*ml*

14.0

D31141

Pivot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pivot

Batch

B36726

*ml*

15.0

D31165

Seal 110-031-4



Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s)

Seal 110-031-4

Batch

B27208

*ml*

16.0

D311611

SEAL



Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)

SEAL

Batch

B27241

*ml*

*ml 08/02/07*

W/O:		WORK ORDER CHANGES					
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Job Number:



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Machine Or Operation:

Description :

17.0

D3119042

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cover Assembly  
Batch B27725

*mul*

18.0

D31202

Cover, Flat Pattern



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cover, Flat Pattern  
Batch B17416

*mul*

19.0

D31204

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cover  
Batch B17424

*mul*

20.0

D31251

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch M10536-17

*mul*

21.0

D31253

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch M10536-17

*mul*

22.0

D31255

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch M10536-17

*mul*

23.0

D31257

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch M10536-17

*mul 08/01/18*

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Machine Or Operation:

Description :

24.0

D31291

Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever

Batch

M10536-17

*ml*

25.0

D31301

Clevis Base



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis Base

Batch

M10536-17

*ml*

26.0

D31311

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Stop

Batch

M10536-17

*ml*

27.0

D31341

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod

Batch

B277338

*ml*

28.0

D31344

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod

Batch

B29699

*ml*

29.0

D314008

Door Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Kit

Batch

B366652D M106688 min 2008/2/15

*ml*

30.0

D31431

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Batch

M10536-17

*ml*

*ml 08/02/07*

W/O:		WORK ORDER CHANGES					
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Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D31433

Clevis



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Clevis M10536-17

*ml*

32.0

D3144117

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch B22022

*ml*

33.0

D3144119

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch B22023

*ml*

34.0

D3144121

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch B22024

*ml*

35.0

D31452

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bracket  
Batch B26708

*ml*

36.0

D31462

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Hinge Bracket  
Batch B23752

*ml*

37.0

D31471

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin  
Batch 30824

*ml 08/01/18*

W/O:		WORK ORDER CHANGES					
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Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

D31491

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Batch

B M10536-17

*ml*

39.0

D31501

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch

M10536-17

*ml*

40.0

D31541

Key



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

Batch

M10536-17

*ml*

41.0

D31571

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

M10536-17

*ml*

42.0

D3159041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

B18641

*ml*

43.0

D3159044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B24687

*ml*

44.0

AN52510R7

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M106166

*ml 08/01/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 36652D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

AN960JD6L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

M5519

*ml*

46.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M106112

*ml*

47.0

AN960JD8L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M6956

*ml*

48.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch

106167

*ml*

49.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

Batch

104374

*ml*

50.0

AN960JD10LL

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

Batch

M19600

*ml*

51.0

ALS463280

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert

Batch

M17841

*ml 08/01/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

BSP45

Commercial Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)  
Commercial Rivet  
Batch M106937

*ml*

53.0

BSP46

Commercial rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Commercial rivet  
Batch M101237

*ml*

54.0

FW4032

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Washer  
Batch M 101203

*ml*

55.0

FW10032

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Washer  
Batch M19249

*ml*

56.0

M7885344

Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Rivets  
Batch M19099

*ml*

57.0

M7885345

Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Rivet  
Batch M 1108

*ml*

58.0

MS203921C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin  
Batch M 18822

*ml 08/01/17*

W/O:		WORK ORDER CHANGES					
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Description :

59.0

MS203922C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M14149

*ml*

60.0

MS203922C15

Pin



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

M101340

*ml*

61.0

MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

M102658(x2) M105558(x5)

*ml*

62.0

MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M106612

*ml*

63.0

MS24665151

Cotter Pin



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

M14526

*ml*

64.0

MS24694C4

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

15924

*ml*

65.0

MS24694S53

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

M15798

*ml* 08/01/17

W/O:		WORK ORDER CHANGES					
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Job Number: 36652D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

66.0

MS24694S56

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

M104407

*ml*

67.0

MS24694S60

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M 11766 (600 11700)?

*ml*

68.0

MS25281R6

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Batch

M19098

*ml*

69.0

MS27039106

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

M106815

*ml*

70.0

MS27039108

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

M105076

*ml*

71.0

MS35206231

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M 11735

*ml*

72.0

MS35650305T

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M11786

*ml 08/01/17*

*we*

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 4:29:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

73.0

MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

M 106421

*ml*

74.0

NAS116910L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

M 11753

*ml*

75.0

NAS38868P

Screw



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Screw

Batch

M 19098

*ml*

76.0

NAS391B6P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

M 19098

*ml*

77.0

NAS43DD340

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

M 11737

*ml 08/01/17*

78.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-04 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB).

Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

*ml 08/02/11*

*PTD*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 08/02/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/07	78	Because the shape of the door, D3130-1 should touch the door But the lever D3125-1 and D3112-1 are longer.	LS 08.02.07	For the lever D3125-1 Work freely, Should add Between D3130-1 and Bottom of door Nylon Washer NAS 1515 H7 M17755	ml 08/02/07	<u>08.02.19</u>	LS 08.02.07	<u>08.02.19</u>

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).
- 5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).
- 6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x 100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).
- 7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).
- 8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.
- 9- Install (1) D3159-044 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.  
Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.
- 10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.  
Note: Position strike plate when big door is in locked position.
- 11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.
- 12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)
- 13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).  
Note: Install D3128-1 shim as required.
- 14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).
- 15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3  
A/R RTV732 Clear Batch: M105700 Expiry: 23 July 2009
- FOR D412-694-011 ONLY
- 16- Drill Pilot holes Ø(#1/8") for D3119-042 cover using drilling Jig D3119-042T1/T2 as per Dwg D412-694 page 3. Trim D3119-042 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).
- 17- Install D3119-042 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB).

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 4:29:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

Align properly.

ml 08/02/11

79.0

QC5

INSPECT WORK TO CURRENT STEP



0802-19 (1)

Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

80.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

(Put red label inside before putting the cover D3119-042/or Vip trim)

ml 08/02/19 (X1)

PTO

81.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08/02/26 (1)

82.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/26 (1)

Job Completion



ml 2008/2/26 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/19	80	Request from QC	<i>[Signature]</i>	add RTV 732 clear M 105700 EX 23 July 2009 in all rivets when install 23116-5 Seal	<i>ml</i> 08/02/19	<i>[Signature]</i> 08-02-19	<i>[Signature]</i> 25/02/19	<i>[Signature]</i> 25/02/19

NOTE: Date & initial all entries

RELEASED

05-12-90

0519363

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-894-01	DOOR ASSEMBLY
	X			D412-894-02	DOOR ASSEMBLY
		X		D412-894-03	DOOR ASSEMBLY
			X	D412-894-04	DOOR ASSEMBLY
		1	1	D3110-1	ESCUTCHEON
			1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0880	SEAL
1	1			D3116-7-0880	SEAL
1	1			D3116-9-0770	SEAL
		1	1	D3119-041	COVER ASSEMBLY
		1	1	D3119-042	COVER ASSEMBLY
		1	1	D3120-1	COVER
		1	1	D3120-2	COVER
		1	1	D3120-3	COVER
		1	1	D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1	1			D3121-043	BRACKET ASSEMBLY (ROLLER)
1	1			D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOOK
1	1			D3124-2	HOOK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SUDBY)
1	1			D3126-3	BRACKET (SUDBY)
5	5			D3126-6	BRACKET (SUDBY)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1	1			D3132-041	ROD WELDMENT
1	1			D3132-042	ROD WELDMENT
1	1			D3133-041	ROD WELDMENT
1	1			D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1	1			D3138-1	COVER
1	1			D3139-2	COVER
1	1			D3139-1	GUARD
1	1			D3139-3	GUARD
1	1			D3139-4	GUARD
		1	1	D3140-05	DOOR
		1	1	D3140-05	DOOR
		1	1	D3140-07	DOOR
		1	1	D3140-08	DOOR
		1	1	D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1	1	D3144-1	DOUBLER
		1	1	D3144-3	DOUBLER
		1	1	D3144-105	DOUBLER
		1	1	D3144-107	DOUBLER
1	1			D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
1	1			D3144-123	DOUBLER
		1		D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
		2	2	D3147-1	FIN
2	2			D3148-1	CLEVIS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1	1			D3152-041	BRACKET ASSEMBLY
		1		D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
		1		D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1	1			D3162-043	BRACKET ASSEMBLY
1	1			D3162-044	BRACKET ASSEMBLY
1	1			D3163-041	COVER ASSEMBLY
1	1			D3163-042	COVER ASSEMBLY
1	1			D3183-041	BRACKET ASSEMBLY (TROLLER)
1	1			D3183-042	BRACKET ASSEMBLY (TROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3208-1	DOUBLER
55	55	21	21	80-035-2-8	INSERT (OR SL2052-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN680JD10	WASHER
18	18	4	4	AN680JD10L	WASHER
13	13	32	32	AN680JD10LL	WASHER
6	6			AN680JD10LL	WASHER
		4	4	AN680JD8L	WASHER
6	6			AN680JD8	WASHER
		2	2	AN680JD8L	WASHER
		2	2	AN680JD8LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSF45	RIVET
		12	12	FWM-032	WASHER
		6	6	FWM-032	WASHER
12	12			M7885-2-4	RIVET (OR CR3213-4-3)
		3	3	M7885-3-4	RIVET (OR CR3212-4-3)
		2	2	MS20392-1C11	FIN
2	2			MS20392-2C15	FIN
2	2	2	2	MS20392-2C17	FIN
2	2			MS20392-2C8	FIN
8	8			MS20392-3C21	FIN
				MS20426AD3	RIVET
12	12			M7885/3-4	RIVET
8	8			MS20426AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
		6	6	MS21043L05	NUT
6	6	2	2	MS21043L08	NUT
		5	5	MS21043L3	NUT
4	4			MS21043L4	NUT
4	4			MS21072L3	NUT PLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24665-S271	SCREW
		2	2	MS24664-C4	SCREW
4	4			MS24664-C5	SCREW
6	6			MS24664-S5	SCREW
18	18			MS24664-S50	SCREW
		4	4	MS24664-S56	SCREW
		2	2	MS24664-S63	SCREW
		4	4	MS24664-S80	SCREW
4	4			MS24664-S88	SCREW
		2	2	MS25281-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-05	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35205-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS35649-254	NUT
		4	4	MS35650-35T	NUT
2	2			MS35650-352	NUT
2	2	3	3	MS31859-7	WASHER
		4	4	NAS1162-10L	WASHER
		14	14	NAS388-6-8P	SCREW
		15	15	NAS39186P	WASHER
7	7			NAS30003-10	SPACER
6	6			NAS30003-14	SPACER
		2	2	NAS30003-40	SPACER

# GENERAL NOTES:

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF, 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JGS. B30-23000-01; D3144-T14-T2-T3; D18703-3; D3162-041T1 (FOR -01 DOOR ASSY); B30-23000-02; D3144-T7-T8-T9; D18703-9; D3152-041T2 (FOR -02 DOOR ASSY); D3144-T4-T5-T6; D3119-041T1; D3112-T14-T2 (FOR -03 DOOR ASSY); D3144-T10-T11-T12; D3119-042T1; D3112-T14-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER DART QS 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER DART QS 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-894-01/02-03-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

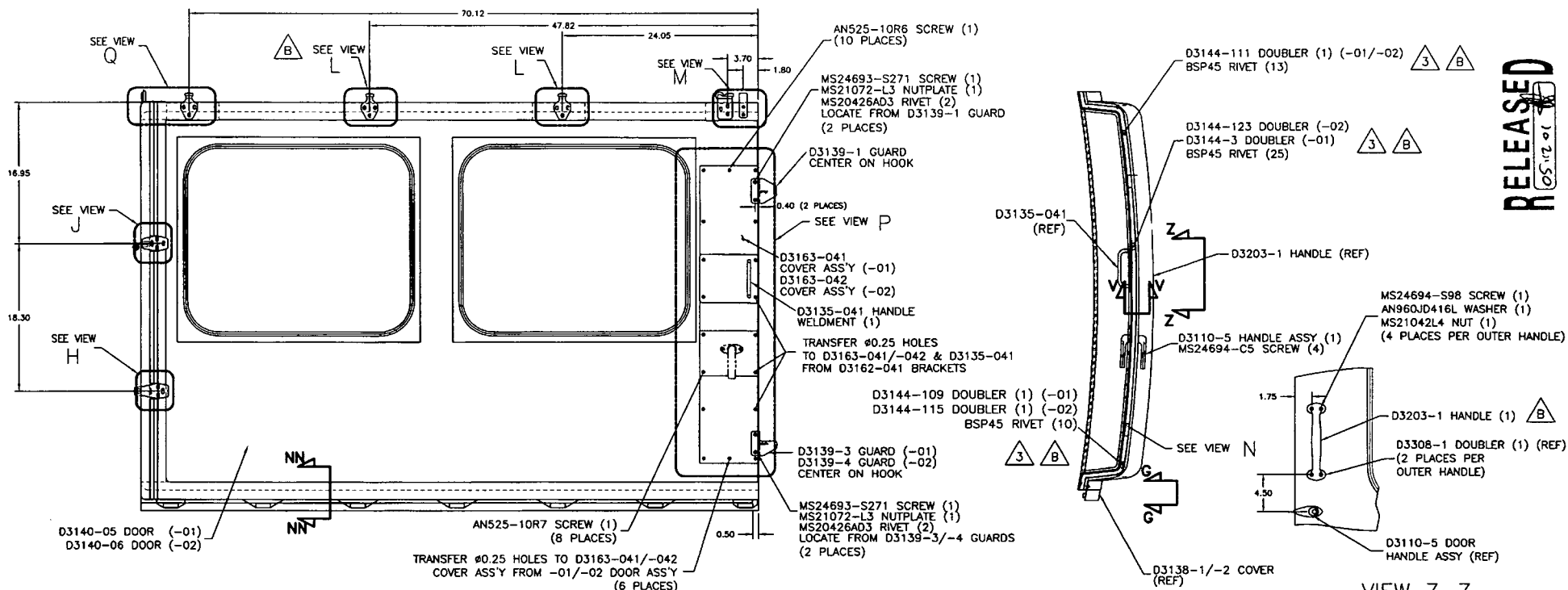
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C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	DRAWING NO. D412-694
		TITLE DOOR ASSEMBLY
		REV. C SHEET 1 OF 6
		SCALE NTS

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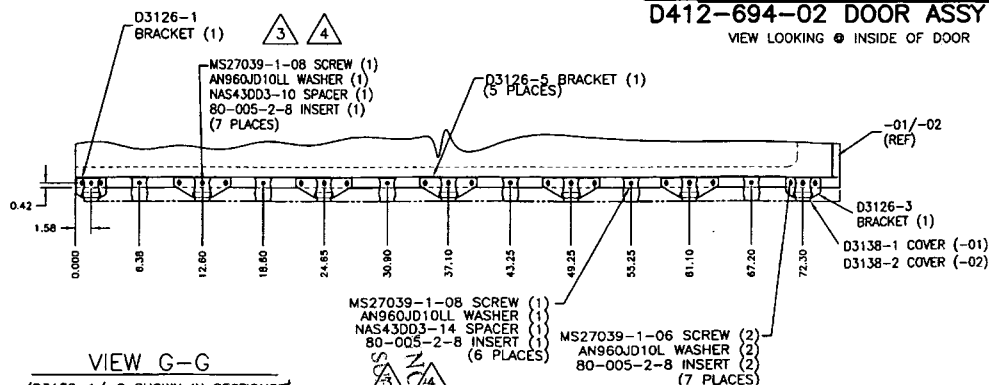
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RELEASED  
05-12-01



**D412-694-01 DOOR ASSY (SHOWN)**  
**D412-694-02 DOOR ASSY (OPP.)**  
VIEW LOOKING @ INSIDE OF DOOR

**VIEW Z-Z**  
**OUTER DOOR HANDLE**  
**INSTALLATION**



**VIEW G-G**  
(D3138-1/-2 SHOWN IN SECTIONS FOR CLARITY OF HDWR LOCATIONS)

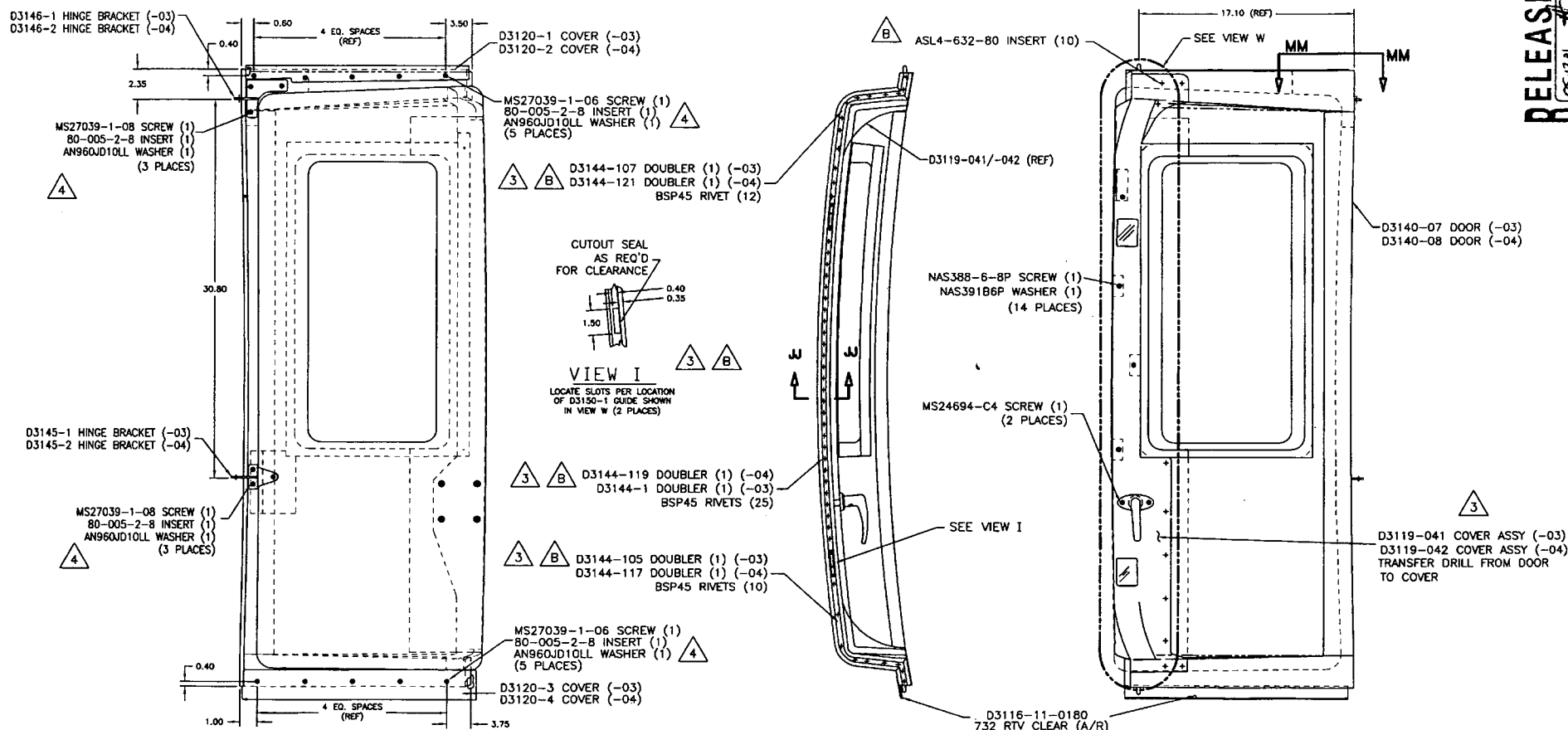
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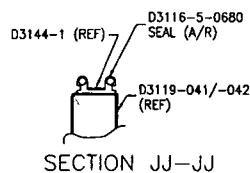
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-694	REV. C SHEET 2 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	

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RELEASED



**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**



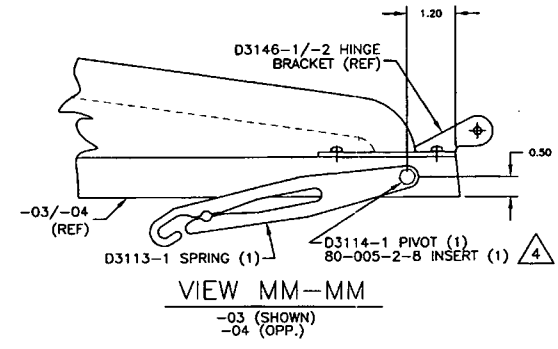
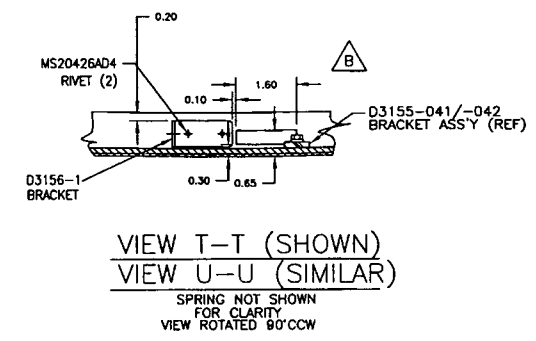
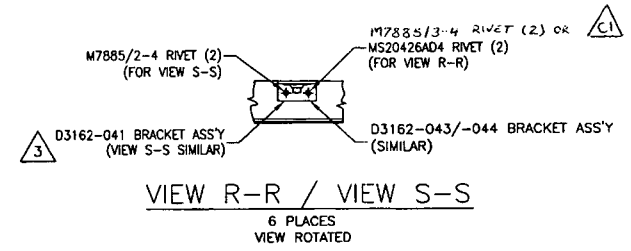
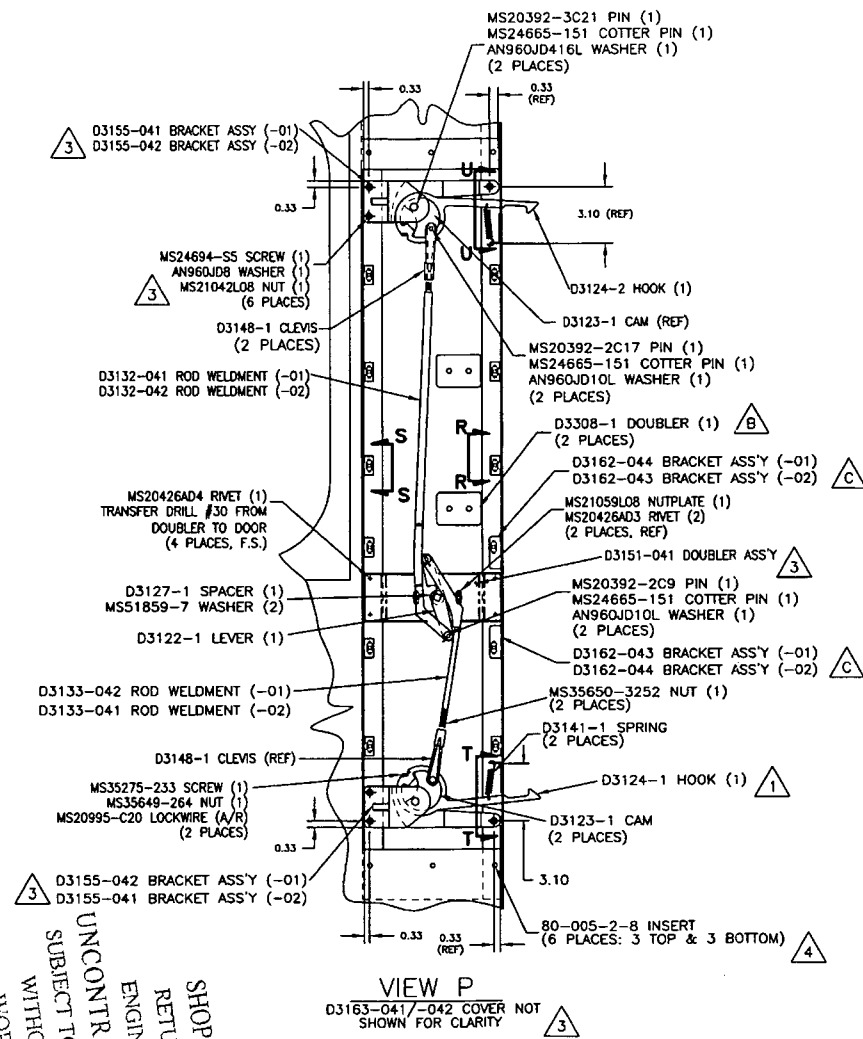
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DESIGN CP	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D412-694	REV. C SHEET 3 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	

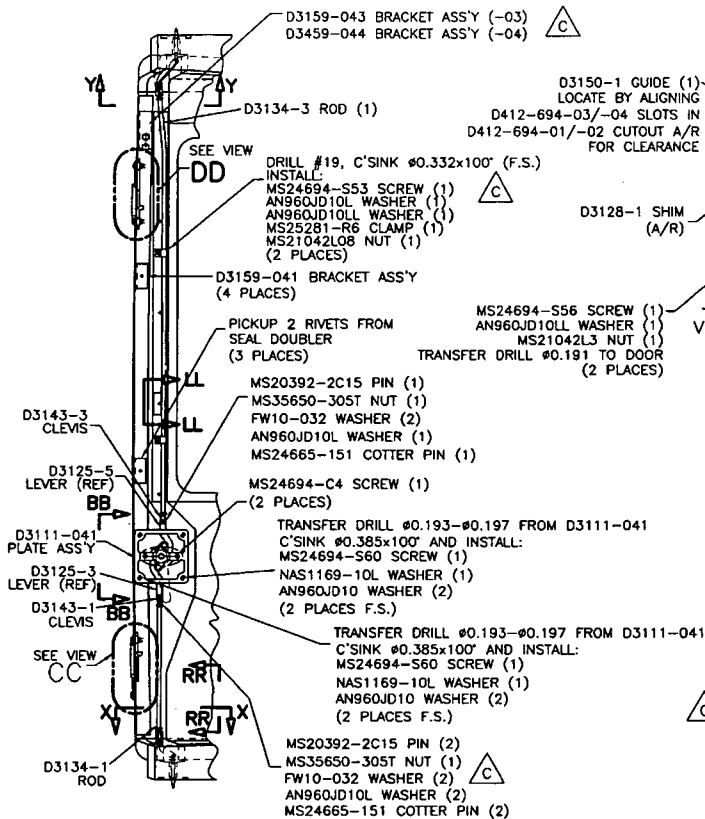
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05.12.01



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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	



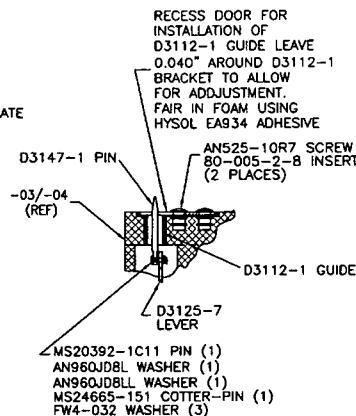
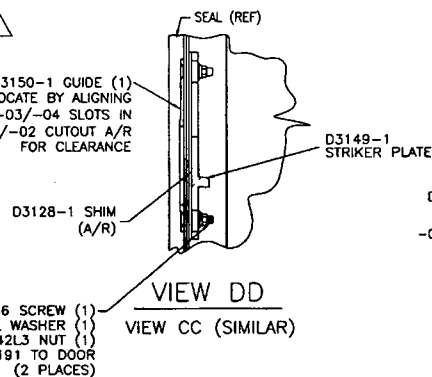


### VIEW W

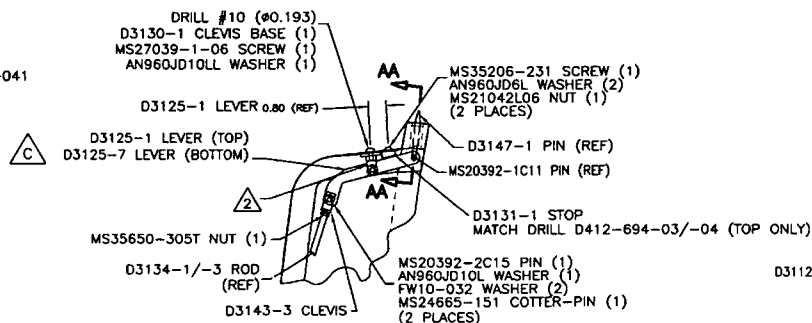
D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY  
SEAL ALSO NOT SHOWN FOR CLARITY

### SECTION LL-LL

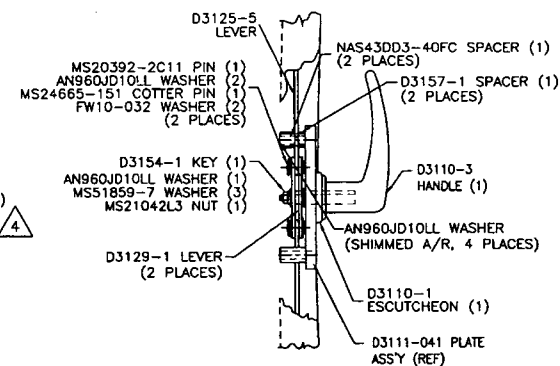
(3 PLACES)  
VIEW ROTATED 90°CCW



### SECTION AA-AA

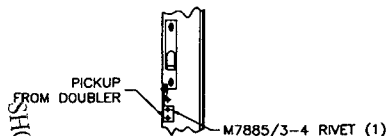
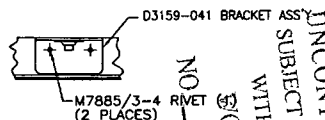
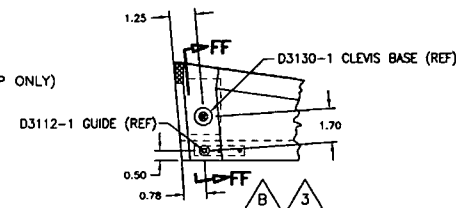


### SECTION FF-FF



### SECTION BB-BB

VIEW SHOWN WITH MECHANISM  
IN THE UNLOCKED POSITION  
FOR CLARITY



### VIEW RR-RR

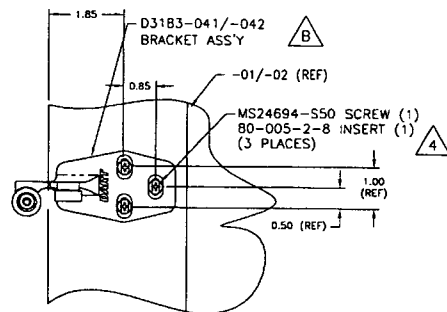
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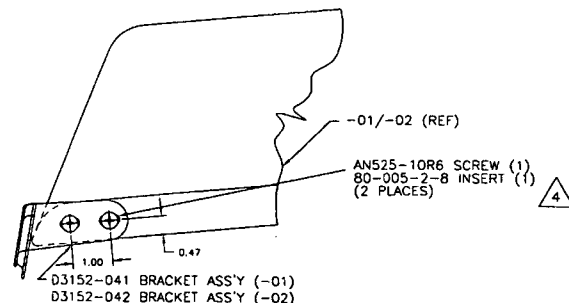
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				D412-694	SHEET 5 OF 6
DATE	05.11.23	TITLE	DOOR ASSEMBLY	SCALE	NTS

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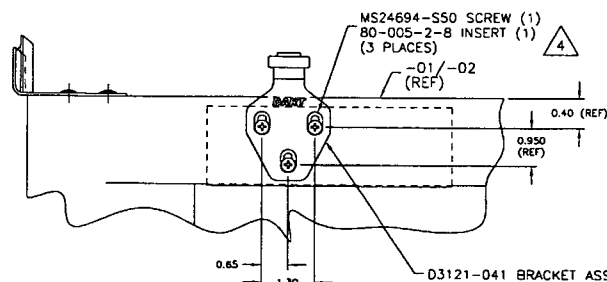
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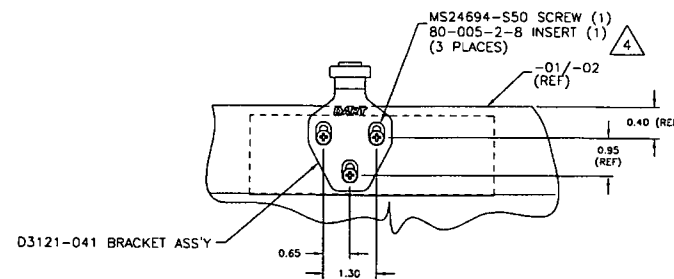
VIEW J



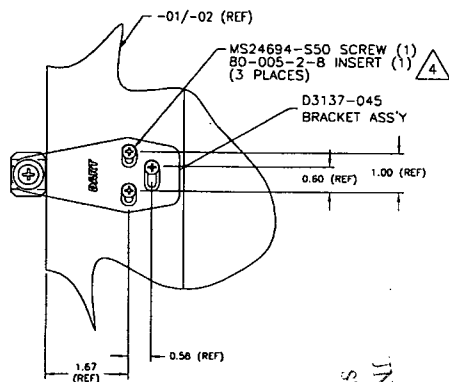
VIEW Q



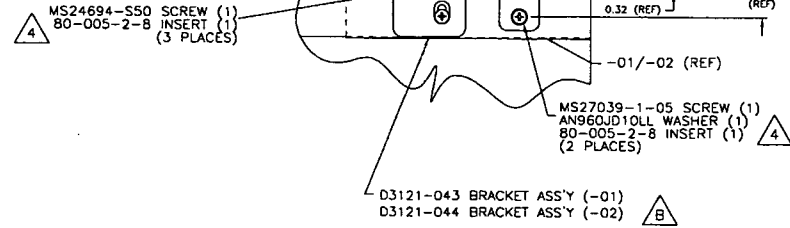
VIEW Q



VIEW L



VIEW H



VIEW M

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